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71 Applicant: MINNESOTA MINING AND
MANUFACTURING COMPANY
3M Center, P.O. Box 33427
St. Paul, MN 55133(US)

72 Inventor: Berg, Harvey J. c/o Minnesota Mining
and Manufacturing Company 2501 Hudson Road
P.O. Box 33427 St. Paul Minnesota 55133(US)

72 Inventor: Krankkala, George E. c/o Minnesota Mining
and Manufacturing Company 2501 Hudson Road
P.O. Box 33427 St. Paul Minnesota 55133(US)

74 Representative: Baillie, Iain Cameron et al,
c/o Ladas & Parry Isartorplatz 5
D-8000 München 2(DE)

54 Molded nonwoven shaped articles.

57 The disclosure relates to a shaped porous article useful as a breath filtering face mask formed from an initially nonunified nonwoven fibrous three dimensional network of one or more types of fibers, at least one of said types of fibers having a continuous coating of a thermally sensitive bonding resin thereon, the fibrous network being thermally unified solely by the coating.

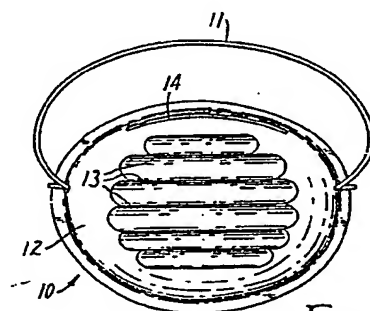


FIG. 2

EP 0 121 299 A2

MOLDED NONWOVEN SHAPED ARTICLESBackground of the Invention

The present invention relates to molded or shaped porous nonwoven fabric articles which are particularly well suited for use as breath filtering industrial and medical face masks. It has noteworthy value in other shaped porous nonwoven articles as diverse as seedling planting containers and filter holding shells.

The desirability of shaping or molding nonwoven webs to a dimensionally predictable and suitably stable form is well known in the art. Thus, see U.S. Patent Nos. 2,609,539, 3,064,329, 3,333,585, and 4,195,112 and Canadian Patent 728,462. These patents illustrate the interest and concern that has existed for many years as well as the methods of shaping fibrous structures by using heat and pressure.

Shaped nonwoven products formed from either bonded fabrics or unbonded webs have achieved wide usage in commerce. They provide the desired form and suitable performance for their intended applications at relatively low cost.

U.S. Patent 2,609,539 involves the steps of shaping the web material on the surface of a mold, heating the material to a bonding temperature, cooling the material and then removing the shaped article from the mold. U.S. Patent 3,064,329 is directed to a process in which the shaped and bonded article was promptly removed from the mold without a cooling step but it was necessary to coat and further interbond the fibers with a latex binder to provide a useful article of commerce. U.S. Patent 3,333,585 discloses a molded cold weather mask made following the general procedures of U.S. Patent 3,064,329, the mask being impregnated after molding with an aqueous dispersion of a hypo-allergenic rubbery acrylic polymer textile sizing latex to coat the fibers and interbond them

at their crossing points. U.S. Patent 4,195,112 describes a process for molding a coherent, pliable, thermally bonded nonwoven fabric and involves the steps of shaping and pressing the bonded fabric on a mold, heating to develop new or stronger thermal bonds, cooling the fabric to retain its shape and then removing the shaped fabric from the mold. Canadian Patent 728,462 is directed to a filter-type face mask in which the fibers of the filter membrane are coated and unified after molding with a rubbery water-insoluble fiber-binding sizing agent.

Summary of the Invention

The present invention provides useful articles of commerce particularly suitable for breath filtering industrial and medical face masks by the shaping and pressing of unbonded fibrous webs on a heated mold with prompt removal of the shaped article from the heated mold and without subsequent coating and interbonding of the fibers with a binding polymeric resin.

Breath filtering face masks must have the properties of low resistance to breathing, of being comfortable to the skin of the face, of being free of unbonded fibers, of having adequate filtration properties, and of being stiff enough to resist the effects of moisture and inhalation resistance.

The stiffness of shaped fabric articles such as face masks is measured in terms of the force (pounds) required to push a 1 inch diameter flat-faced probe 1.25 inch into the shaped article with motion from the outside of the article and perpendicular to the base of the article. The equipment used is a King Fabric Stiffness Tester Model GFC10A with digital Chatillon force gauge, modified by the addition of a suitable platform to provide repeatable spatial location of the base of the shaped article. Downstroke speed is critical to test repeatability. Flow controllers and pressure regulators are set so that the Chatillon probe crosses a 2.0 inch gap in the

center of its stroke in a time of 1.13 seconds to 1.14 seconds.

The pressure drop of the face mask is measured in millimeters of water pressure by passing 32 lpm of air through the mask. The pressure drop is measured either with a Dwyer Model M-171 (0-6 mm water) Manometer or a Dwyer Model 424 (0-130 mm water) Manometer. Suitable chucks are used to hold the mask tightly about the periphery so that an airtight seal is accomplished. Molded nonwoven masks with pressure drops up to 15mm meet user expectations for ease of breathing, but lower pressure drops are desirable. For example, commercial face masks made according to U.S. Patent 3,064,329 have a minimum stiffness of 0.55 pounds, a maximum pressure drop of 2.3 mm. of water and meet the other criteria of an acceptable face mask.

Brief Description of the Drawings

Figure 1 is a side elevation showing a cupped-shaped mask as worn upon a face; and

Figure 2 is a frontal view of the mask of Figure 1.

Detailed Description of the Invention

Referring now more particularly to the drawings, it will be seen that the cupped-shaped mask 10 when worn on the face makes a snug low-pressure marginal contact between fabric and skin and conforms to the face so as to extend over the bridge of the nose, under the eyes, over the cheeks and under the chin. The margin of the mask is flared to meet the face at a comfortable acute angle which provides a sealing relationship. The mask is held in place by a light elastic head band 11. The cupped-shaped body 12 of the mask comprises a thin porous fabric which is sufficiently stiff but flexible and springy so as to be comfortable and yet retain its shape and avoid collapse during inhalation. The body may be provided with several horizontal corrugations or ribs 13 across the front to

further stiffen and increase resistance to collapse. A thin pliable strip 14 of aluminum is provided at the top edge of the mask to further assist in conforming the mask to the nose of the wearer by pinching the strip 14 to the contour of the nose bridge. As shown by the dashed-line facial profile, the mask stands out from the face and does not touch the tip of the nose, the mouth or the chin and it permits adequate jaw movement for comfortable speaking and breathing.

The following steps are employed in fabricating the porous shaped fabric articles of this invention such as face masks.

1. A dry fluffy fibrous web or batt is formed from one or a mixture of fibers by carding or by a standard air layering process such as with a "Rando Webber" machine sold by Rando Machine Corporation, Macedon, New York. When one type of fiber is used, the fibers are precoated and where a mixture of fibers is used, at least one type of those fibers is precoated, the coating having a significantly lower softening temperature than its concomitant base fiber. The resulting coherent but unbonded web or batt is a collection of fibers interlaced into a loose fluffy web wherein the fibers cross over and under each other so as to be held together in three dimensions by mechanical and frictional forces.

2. A dry fluffy sheet of suitable size is cut from the aforesaid air laid nonwoven web and is fitted over a heated male mold having the desired contour. A male mold of rigid silicone heated by conductive electric heating is preferred. The surface temperature of the male mold is sufficient to soften the coating of the coated fibers. The fluffy sheet is rapidly conformed (as by hand smoothing) to an unwrinkled approximate fit, the fibers being able to shift about to make this possible without wrinkling or impairing the uniformity of the web and without stretching the fibers.

3. A heated, Teflon-coated female mold of cast aluminum and of complementary contour to the male mold is promptly brought against the web-covered male mold so that a relatively uniform soft pressing action is exerted on the intervening web. The surface temperature of the female mold is sufficient to soften the coating of the coated fibers. This results in a final and precise molding of the web to the shape of the mold, the fibers still being able to move in the initial phase of this step; and the web is simultaneously compacted by the soft pressing action. The coating of the coated fibers becomes heated sufficiently by the hot molds to soften and wet the surfaces of compatible fibers at their mutual crossover points. A compatible fiber is one where the contact angle with the softened coating is low enough that surface wetting occurs. The heating and pressing are insufficient to cause mashing or cutting of fibers, and fiber identity is retained.

4. The pressure forcing the molds together is released and the molds are separated. The exposed molded article is grasped about its periphery and lifted from the hot male mold, no intervening cooling being required. The article does not stick to the hot mold and can be easily and bodily lifted away without being distorted. Upon cooling, the resulting article is sufficiently stiff to function as a face mask without the addition of a separate binder system.

It will be apparent that a plurality of molds can be combined into a single production unit to produce porous shaped non-woven articles of the present invention on a mass production basis.

The following examples will more fully illustrate the invention. While the examples are specifically directed to shaped non-woven face masks, it will be apparent that numerous other shaped articles can be produced by following the teachings of the examples.

Example 1

A dry fluffy fibrous web was formed on a Rando Webber utilizing 4 dpf x 51 mm all polyester sheathed fibers at a basis weight of 100 pounds per ream (320 yd²).

5 The fiber is believed to comprise a core of polyethylene-terephthalate and a sheath of polyester resin comprising a random copolyester composite of 68% terephthalic acid units and 32% isophthalic acid units polymerized with ethylene glycol, and is available as "Melt Fiber Type 4080" from
10 Unitika, Ltd., Osaka, Japan. The fiber core (base fiber) has a melting temperature of approximately 245°C. The sheath has a sticking temperature of about 110°-120°C, as described below in Example 7.

A dry fluffy fibrous sheet cut to a convenient
15 size from the above formed web was shaped over a heated rigid cupped-shaped silicone male mold maintained at 250°F, which is above the sticking temperature of the fiber sheath, the loose fibrous state permitting of conformation over the mold.

20 This shaped fluffy sheet is then promptly subjected to uniform soft-pressing by bringing a heated, aluminum female mold of complementary contour to the male mold against the web covered male mold to compact and unify the web to a stable molded shape precisely conforming to
25 the molds. The mask molds are preferably contoured to produce a mask having a cupped-shaped body portion having an area in the range of 25 to 27 square inches. The molds may be ribbed or corrugated to further strengthen and stiffen the cupped-shaped masks. The molding time is about
30 six seconds at a temperature of about 250°F and a pressure of about 215 pounds applied over a projected area of 35.75 square inches.

The stiffness of the molded mask was 1.71 pounds, measured on the King Fabric Stiffness Tester.

35 The air pressure drop of the molded mask, measured by the Dwyer Manometer, was 0.6 mm. of water.

Example 2

5 A dry fluffy fibrous web was formed according to the procedure set forth in Example 1 with 50% by weight of "Melt Fiber Type 4080" and 50% by weight of polyester staple fibers, 6 dpf x 2 inch, Type 476, Finish 75, semi-dull, crimped (Celanese Fiber Industries, Inc., Salisbury, N.C.), at a basis weight of 100 pounds per ream. The melting point of the Celanese polyester staple fiber is approximately 245°C. The web was molded as set forth in
10 Example 1 and produced a molded mask having a stiffness value of 0.91 pounds on the King Fabric Stiffness Tester and an air pressure drop of 0.35 mm. of water.

Example 3

15 A dry fluffy fibrous web was formed according to the procedure set forth in Example 1 with 75% by weight of "Melt Fiber Type 4080" and 25% by weight of polyester staple fibers, 6 dpf x 2 inch, Type 476, Finish 75, semi-dull, crimped (Celanese), at a basis weight of 65 pounds per ream. The web was molded as set forth in Example 1 and
20 produced a molded mask having a stiffness value of 0.20 pounds on the King Fabric Stiffness Tester and an air pressure drop of 0.2 mm. of water. Surprisingly, this molded shape with a stiffness value as low as 0.20 lbs. showed adequate efficacy as a face mask.

Example 4

25 A dry fluffy fibrous web was formed according to the procedure set forth in Example 1 with 75% by weight of "Melt Fiber Type 4080" and 25% by weight of electrically charged fibrillated isotactic polypropylene fibers, about
30 40 x 10 microns in cross section x 38 mm. length, "Filtrete Type G" (3M Company, St. Paul, MN) at a basis weight of 100 pounds per ream. The melting point of the Filtrete Type G fibers is approximately 165°C. The web was molded as set forth in Example 1 and produced a molded mask having a
35 stiffness value of 1.12 pounds on the King Fabric Stiffness

Tester and an air pressure drop of 0.75 mm. of water.

Example 5

5 A dry fluffy fibrous web was formed according to the procedure set forth in Example 1 with 50% by weight of "Melt Fiber Type 4080" and 50% by weight of viscose rayon fiber, 3 dpf x 2 inch, (American Enka Company, Des Plaines, IL) at a basis weight of 100 pounds per ream. The web was molded as set forth in Example 1 and produced a molded mask having a stiffness value of 0.68 pounds on the King Fabric
10 Stiffness Tester and an air pressure drop of 0.45 mm. of water.

Example 6

15 A dry fluffy fibrous web was formed according to the procedure set forth in Example 1 with 50% by weight of "Melt Fiber Type 4080" and 50% by weight of wood pulp fiber, average fiber length of 2.2 mm, Rayfluff-X-Q (ITT Rayonier Inc., New York, NY) at a basis weight of 100 pounds per ream. The web was molded as set forth in Example 1 and produced a molded mask having a stiffness
20 value of 0.62 pounds on the King Fabric Stiffness Tester and an air pressure drop of 0.6 mm. of water.

Examples 1 through 6 show that a precoated textile type fiber, such as "Melt Fiber Type 4080" by itself or blended at a suitable ratio with other type fibers, such
25 as specified in Examples 2 through 6, can be formed into a nonwoven web and molded to form an article which is sufficiently stiff, free of fuzz, and comfortable to the face so as to function as a face mask without the subsequent addition of a separate polymeric resin binder
30 system to impart stiffness.

It was observed that webs comprised entirely or partially of Melt Fiber Type 4080, similar to those discussed in Examples 1 to 6, stuck to the molds when the molding temperature was about 300°F or higher. To insure
35 proper molding, it is necessary that the molding temperature

be above the sticking temperature of the polymer coating but below the softening point of the base fiber so that the fibrous nature of the molded article is maintained. However, it is believed that as the molding temperature approaches the temperature range where the melt flow of the coating is significant, sticking of the molded article to the mold surface can occur.

Examples 7-13

A dry, fluffy fibrous web was made utilizing polyester staple fibers, 6 dpf x 2 inch of Example 2 (Celanese) by the method described in Example 1. The basis weight of the web was 88 pounds per ream. A 25% solids solution of Vitel PE-200 (amorphous non-crystallizable copolyester manufactured by Goodyear) in methyl ethyl ketone and toluene was squeeze roll coated onto the polyester web. After drying, the web was reweighed and showed that 32 pounds per ream of the amorphous copolyester was deposited on the fibers of the web.

The coated web, which was now highly compacted and with the fibers tightly bonded together, was "reopened", using conventional means, such as the lickering portion of a Rando Webber, and formed into a lofty fibrous web. This lofty fibrous web was molded following the procedure of Example 1 to yield a face mask which was sufficiently rigid without the use of a separate binder system.

The same procedure was repeated using other base fibers and polymeric coatings whose physical properties are summarized in Table I.

The polymeric coatings are characterized by the temperature at which they stick to stainless steel. The sticking temperature is the temperature at which the polymeric coating begins to adhere to the stainless steel top of a Kofler hot bench. At this temperature the polymeric coating also adheres to itself under the pressure of molding.

Table I

Ex. No.	Base Fiber	Polymer Coating	Sticking Temp. °C (Range)	Mold Temp. °C	Wt. Ratio Coating:Fiber	Stiffness (lbs.)	Pressure Drop (mmH ₂ O)
7	Polyester 6.0 dpf x 2 in. Copolyester (Oelane) (Goodyear) m.p. 245°C	Vitel PE-200	110-120	120	36/100	2.10	0.9
8	Polyester	Elvace 1974 Ethylene- vinylacetate (Dupont)	90-100	120	16/100	.88	0.5
9	Polyester	Geon 580X158 Vinyl Chloride (Goodyear)	140-160	190	28/100	.88	0.3
10	Polyester	Hycar 26084 Acrylic (Goodyear) Coated at pH 8-9	110-120	190	42/100	1.08	1.4

Table I (continued)

Ex. No.	Base Fiber	Polymer Coating	Sticking Temp. °C (Range)	Mold Temp. °C	Wt. Ratio Coating:Fiber	Stiffness (lbs.)	Pressure Drop (mmH ₂ O)
11	Rayon	Elvace 1874	90-100	120	13/100	1.01	1.03
	3.0 dpf x 2 in. (American Enka) does not melt, discolors at 230°C						
12	Rayon	Vitel PE-200	110-120	120	27/100	2.02	1.0
13	Rayon	Geon 580X158	140-160	190	23/100	.96	1.1

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The data from Examples 7 to 13 show that molded shapes with adequate stiffness, free of fuzz, and comfortable to the face can be made from solution or emulsion coated fibers provided that the molding temperature is above the sticking temperature of the coating (Table I) and below the softening temperature of the concomitant base fiber. It is contemplated that the coated fibers of Examples 7 to 13 can be blended with other fibers as in Examples 2 through 6 to form suitable molded shapes.

10 In an effort to determine whether shaped nonwoven products could be produced by utilizing the components in a form other than a base fiber with a coating in intimate association with the base fiber, the following experiment was carried out. Melt blown fibers were produced from a
15 polyester resin comprising a random copolyester composite of 80% terephthalic acid units and 20% isophthalic acid units polymerized with ethylene glycol. In the melt blown fiber process, the polymer is converted into nonwoven webs directly from the melt by extruding, attenuating, cooling,
20 and collecting fibers on a moving belt in a rapid continuous fashion generally as taught in U.S. Patent 3,971,373. The attenuation and cooling are done with airstreams acting at the point of extrusion. These fibers showed a melting point of 160°C. The melt blown polyester
25 nonwoven web was subsequently "opened" and mixed with 50% by weight of polyester staple fiber, 6 dpf x 2 inch of Example 2 (Celanese). The fiber mixture was used to produce an air laid nonwoven web as described above in Examples 2-6 at a basis weight of 100 pounds per ream. The
30 web was molded as set forth in Example 1 for six seconds at a temperature of about 250°F and a force of about 215 pounds over a projected area of 35.75 sq.in. The molded form stuck to the mold and was deformed in removal from the mold. While the stiffness of the molded form was 0.35
35 pounds, the surface of the molded form was rough and fuzzy, uncomfortable during wearing and would require at least additional interfiber bonding with a polymeric latex to be

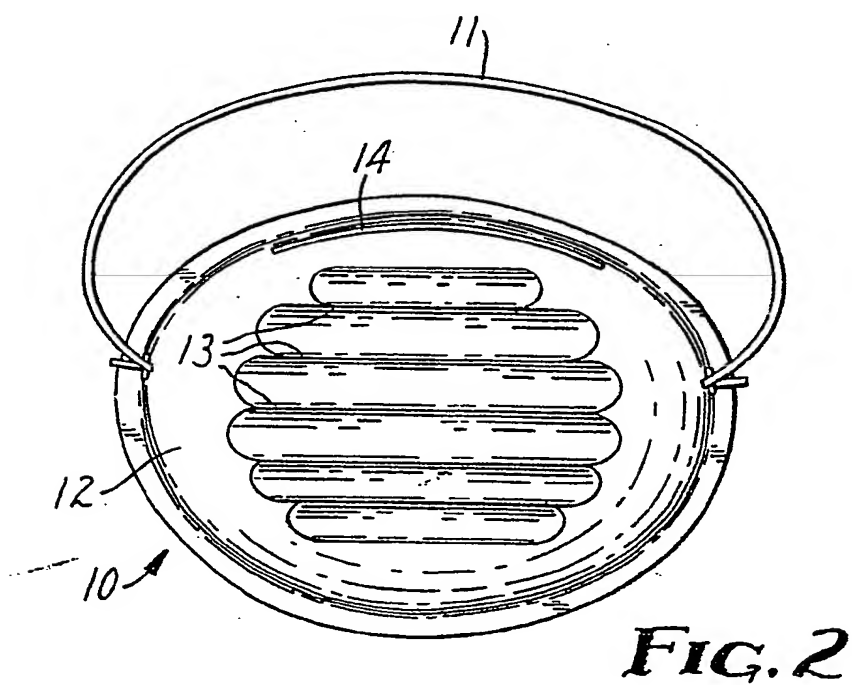
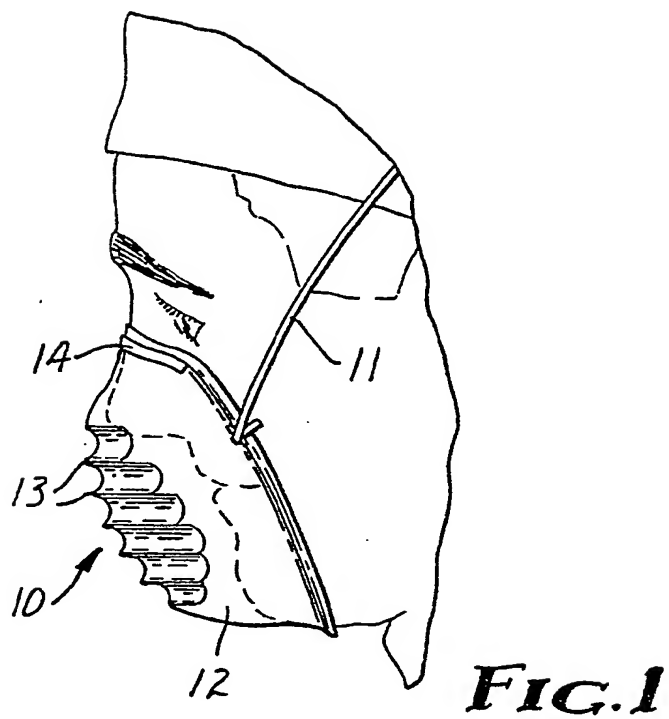
a useful molded mask. This experiment clearly shows that although a bonding material of substantially the same chemical composition as the sheath of the "Melt Fiber Type 4080" (the melt blown polyester fibers) is utilized, unless
5 the bonding material is present as an intimate coating on the base fiber, a useful product cannot be produced.

Claims:

1. A shaped porous article useful as a breath filtering face mask comprising an initially nonunified nonwoven fibrous three dimensional network formed from fibers which are dimensionally stable at the shaping conditions, said fibers having a continuous
5 coating of a thermally sensitive bonding resin thereon, said fibrous network being thermally unified solely by said coating mainly at the crossing points of the fibers, said article having a stiffness value of at least 0.2 pounds and being capable of passing 32 liters of air therethrough at a pressure drop of
10 not over 15 mm of water.
2. A shaped porous article according to claim 1 wherein said fibers comprise polyester sheathed fibers comprising a core of polyethylene terephthalate and a sheath of a random
15 copolyester composite of terephthalic acid units and isophthalic acid units.
3. A shaped porous article according to either of claims 1 and 2 wherein said initially nonunified nonwoven fibrous three
20 dimensional network is formed from a mixture of two types of fibers, at least one of said types of fibers having a continuous coating of a thermally sensitive bonding resin thereon.
4. A shaped porous article according to any one of claims
25 1 to 3 additionally including one or more of polyester staple fibers, electrically charged fibrillated isotactic polypropylene fibers, viscose rayon fibers, wood pulp fibers.
5. A shaped porous article according to any one of claims
30 1 to 4 wherein said continuous coating of thermally sensitive bonding resin on said fibers has been applied from a liquid.
6. A shaped porous article according to any one of claims 1 to 5 wherein said fiber is polyester and said thermally sensitive

bonding resin is selected from ethylene-vinylacetate, amorphous polyester, plasticized polyvinyl chloride or acrylic.

7. A shaped porous article according to any one of claims
5 1 to 6 wherein said fiber is rayon and said thermally sensitive bonding resin is selected from ethylene-vinylacetate, amorphous polyester or polyvinyl chloride.



THE UNIVERSITY OF CHICAGO

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71 Applicant: **MINNESOTA MINING AND MANUFACTURING COMPANY**
3M Center, P.O. Box 33427
St. Paul, Minnesota 55133-3427(US)

72 Inventor: **Berg, Harvey J. c/o Minnesota Mining and Manufacturing Company 2501 Hudson Road P.O. Box 33427 St. Paul Minnesota 55133(US)**

72 Inventor: **Krankkala, George E. c/o Minnesota Mining and Manufacturing Company 2501 Hudson Road P.O. Box 33427 St. Paul Minnesota 55133(US)**

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54 **Molded nonwoven shaped articles.**

57 The disclosure relates to a shaped porous article useful as a breath filtering face mask (10) formed from an initially nonunified nonwoven fibrous three dimensional network of one or more types of fibers, at least one of said types of fibers having a continuous coating of a thermally sensitive bonding resin thereon, the fibrous network being thermally unified solely by the coating.

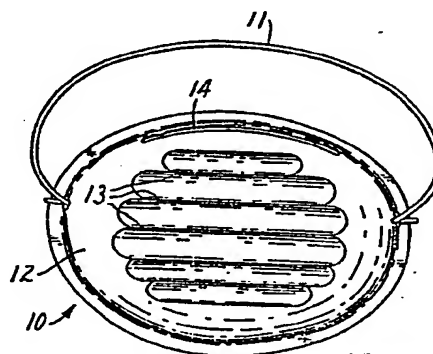


FIG. 2



European Patent
Office

EUROPEAN SEARCH REPORT

0121299
Application number

EP 84 30 0640

DOCUMENTS CONSIDERED TO BE RELEVANT			
Category	Citation of document with indication, where appropriate, of relevant passages	Relevant to claim	CLASSIFICATION OF THE APPLICATION (Int. Cl. 3)
Y	DE-A-3 007 343 (BORGERS) * Claims 1,2 * ---	1,3	D 04 H 1/00 A 41 D 13/00
D,Y	US-A-4 195 112 (ICI) * Claims 1-3,6-8; example I * ---	1-3	
D,Y	US-A-3 333 585 (MINNESOTA) * Claim * ---	1	
A	US-A-3 220 409 (JOHNSON & JOHNSON) * Claims 1,8-12 * ---	1,7	
A	US-A-3 499 810 (DU PONT) * Claims 1,3,5 * -----	1,3,5,6	
			TECHNICAL FIELDS SEARCHED (Int. Cl. 3)
			D 04 H A 41 D
The present search report has been drawn up for all claims			
Place of search THE HAGUE		Date of completion of the search 01-04-1986	Examiner CATTOIRE V.A.
CATEGORY OF CITED DOCUMENTS			
X : particularly relevant if taken alone Y : particularly relevant if combined with another document of the same category A : technological background O : non-written disclosure P : intermediate document		T : theory or principle underlying the invention E : earlier patent document, but published on, or after the filing date D : document cited in the application L : document cited for other reasons & : member of the same patent family, corresponding document	

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